2- deburr and break all sharp edges

1-Machine per folio FB130 DWG REV: W/A FOLIO REV: A

HAAS CNC vertical machine #1

NCR:	/es	/ No	·			WORK ORDER NON-	CO	<b>VFORN</b>	MANCE / UPDATE		•		_	i.a.
											QA Closed:	Da	ete:	
Work Orde	or.					DISPOSITION			AGAIN	IST DE	PARTMENT	PROCESS		
Part f	- . No.					Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Crosstu Machining Small I noforming Finish Large Fab Compos	ab ing	4	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verificatio	on	QC Inspector
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other			1											
Process	Щ													
Supplier														
Training														
Unapproved			1					<b>-</b>	200		<u>L</u>			
						·····	AUL	LT CATE	JORY					
Landi	_				<b></b>	General		10			Journal			Pressure/Forced
	Н	Bending	- 4 . 6		~  -	Bend BOM/Route	$\vdash$	Grain		$\vdash$	Ovalized Over/Under	+01040000	$\vdash$	Temperature/Cure
	-	Centre No	ot Conce	ntric to t	)/5	BOM/Route	<u>,</u>	Hardwa			Part Incorre		$\vdash$	Weld
		Cracks	C:		-	Broken/Damaged Burrs	-	-1	ori Incomplete ions Incomplete/Unclear	-	Part Lost/Mi		$\vdash$	Wrong Stock Pulled
	$\vdash$	Crushed/ Cuffs	Crimpea		<u> </u>	Contamination	-	Mainte	•	-	Part Moved	issirig	Ш	Wrong Stock Fulled
ĺ	H	Heat Trea	at .		-	Countersink	-	Mislabe		-	Positioned V	Mrong		
		Inspectio		Tubo	-	Cut Too Short	-	Misread		-	Power Loss/	<del>-</del>		Other
	Н	Ripples in	-	·	-	Drill Holes	-	Offset	ı	L	J. 0WC, 2033/	Juige	L	Ottici
		Torque W		Extrusion	,   <u> </u>	Drawing	<b> </b>	4	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

October-10-12		+37 		*914	39*			Page 2
Item ID: Revision ID: Item Name:	646.9710 Body		4	Accept	*N900040	100*	Setup Star	14.21
Start Date: Required Date: Reference:	10/10/12 10/31/12	<b>Start Qty:</b> 56.00 <b>Req'd Qty:</b> 56.00	*56* *56*		Cust Item ID: Customer:		- 0	
Approvals:		n:	Date:	Tooling: SPC (Y/N):	Date:		Run Star Stop	
Sequence ID/ Work Center II  120  *170* QC Quality Control	D	Operation Description QC2- Inspect parts off ma	chine FAI/FAIB	Set Up/ Run Hours  0.00  AS  14  0.00  9-89	Tool ID Tool#	Plan Accept Code Qty	Reject Qty	Reject Insp. Number Stamp
130 *130* QC Quality Control		QC8- Inspect parts - secon	nd check remove at	0.00 0.00 // marking	100 25 10-11-15	<u>60</u>		211.20
*140 *140* Outsource4 Outsource process	- Anodize	Outsource process-Anodi  Memo Issue P/O: Black Anodi	ze per QSI017 4.1.10.1  / SOC ze as per Dwg 646.9700	0.00		———	pl_ <sub>[2</sub> -	11-26

									DQA	:Date:	
NCR: Ye	es / No	·			WORK ORDER NON-C	CONFORI	MANCE / UP	DATE	QA Closed	: Date:	*
					DISPOSITION		<u> </u>	AGAINST	DEPARTMENT		
Work Ordei	r:				DISPOSITION	.		AGAINST			- <del></del>
Part N	0				Rework Scrap Use-as-is	- I	Skid-tube Machining moforming	Crosstube Small Fab Finishing	<del></del>	Water Jet od. Eng. Coor ore/Packaging	Engineering Quality Other
NCR N	0		***		Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling						•			.		
Operator											
Material											
Setup		1	]						ļ		
Other						8					
Process											
Supplier											
Training						]					
Unapproved											
					· F.	AULT CATE	GORY				
Landin	g Gear				General						_
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to 0	o/s	BOM/Route	Hardwa	are		Over/Unde	r tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	tior Incomplete		Part Incorr	ect	Weld
	Crushed/	Crimped			Burrs	Instruc	tions Incomplete/	/Unclear	Part Lost/N	Missing	Wrong Stock Pulled
ļ	Cuffs				Contamination	Maint	enance		Part Move	d	_
F	Heat Trea	at			Countersink	Mislab	eled		Positioned	Wrong	
	Inspectio		Tube		Cut Too Short	Misrea	d		Power Loss	s/Surge	Other
-  -	Ripples in	•		<b></b>	Drill Holes	Offset		•	<b>—</b>	<u></u>	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

<b>Work Ord</b> October-10-12		439		*914	139*							Page 3
Item ID: Revision ID: Item Name:	646.9710 Body			Accept	*N900	<b>040</b>	100	)* s	Setup	Start Stop	ı v.	S1* S2*
Start Date: Required Date: Reference:	10/10/12 : 10/31/12	<b>Start Qty:</b> 56.00 <b>Req'd Qty:</b> 56.00	*56* *56*		Cust Item I Customer:	D:						
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center I 150	D	Operation Description Receive & Inspect for Da	mage & Mat'l Certs	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp
*150* Packaging Packaging		Memo		0.00				,	<u> </u>	2 12	[[2]]	f (60)
155 +4 F F +		QC5- Inspect part comple	eteness to step on W/O	0.00				<i>(</i> n			(	DAS 05
*155* QC Quality Control		Memo		0.00				60		va holdda		9-89 / IL //2 · 2
*160		Spray Painting per QSI00	05 4.2	0.00						<b>.</b> ∕.	æ	Λο
SprayPaint Spray Painting		<b>Memo</b> PRIME AS I	PER DWG, SEE NOTE #2	0.00				_ 60		Φ	<i>\_</i>	13-1-8

CARDINAL 4860-50 PRIMER BATCH: 123693

												DQA:	Da	te:	
NCR: \	⁄es	/ No				WORK ORDER NON-	COI	NFORN	MANCE / UPI	DATE	OA C	:losed:	Da	te:	*
						DISPOSITION	,			AGAINST DE		======			
Work Orde	er: _						٦				1	•			
Part N	۱o					Rework Scrap Use-as-is		ı	Skid-tube Machining Inoforming	Crosstube Small Fab Finishing	l B		Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR I	۰۱٥.					Work Order Update	_	3	Large Fab	Composite	] '``		Supplier		
Root					Descri	ption of work order update		Initial	Act	ion	Sig	n &			
Cause		Date	Step	Qty	C	or Non-conformance	Cr	nief Eng	Descr	iption	D	ate	Verificatio	n	QC Inspector
Doc/Data											ļ				
Equip/Tooling	$\dashv$														
Operator	$\dashv$														
Material	$\dashv$														
Setup	-														
Other Process	$\dashv$														
Supplier	$\vdash$							18					]	i	
Training			1												
Unapproved	$\vdash$														
			1	<u>.                                    </u>	<b>L</b> .	F	AUI	LT CATE	GORY		<u></u>	•			
Landi	ng G	iear				General									
	$\overline{}$	Bending				Bend		Grain			Oval	ized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over	/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part	Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Jnclear	Part	Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		]Mainte	nance		Part	Moved			
		Heat Trea	at			Countersink		Mislabe	led		Posit	tioned \	<b>N</b> rong		-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I	[	Pow	er Loss,	/Surge		Other

Offset

Out of Calibration

Out of Secuence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing Finish

Work Orde		439		*914	139*						Page 4	
Revision ID:	646.9710 Body			Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Start Stop	14.	S1* S2*	
Start Date: Required Date: Reference:	10/10/12 10/31/12	<b>Start Qty:</b> 56.00 <b>Req'd Qty:</b> 56.00	*56* *56*		Cust Item I Customer:	D:						
Approvals:		an:	Date:			ate:		R	un Start Stop		₹1* ₹2*	
Sequence ID/ Work Center II 170 *170* QC	)	Operation Description QC14- Inspect Spray Pain	nt	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp  OAS   05   /3.02.0	2
Quality Control  180  *180* Packaging Packaging		Memo Identify as per dwg & Sto  Memo  ***IDENTIF	ck Location 139 /	0.00	# AND REV***				013/	2/4	(60)	
190 <b>*190</b> QC QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					13/	2/5	4	,

AB02-M

												DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	AANCE / UP	DATE					•
												QA Closed:	Date	e:	<b></b>
Work Ord	er.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Part :	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	otion of work order update	1	Initial	Ac	tion	-	Sign &	·		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification		QC Inspector
Doc/Data															
Equip/Tooling			ļ											1	
Operator															
Material															
Setup	10		Ĺ												
Other	Ŀ					•							-		
Process			j					i							
Supplier														:	
Training			ļ												•
Unapproved															
						· F	AUL	T CATE	GORY						
Land	ing (	Gear				General		_					_		
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct [		Weld
		Crushed/	Crimped.			Burrs		Instruct	ioris Incomplete/	'Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved	-		
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong		
l		Inchactio	n Strin ín	Tubo		Cut Too Short		Microso	1			Power Loss	Surga		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

**Drill Holes** 

Drawing

Finish

## **Picklist Print**

. October-10-12 9:51:19 AM

Work Order ID:

91439

Parent Item:

646,9710

Parent Item Name:

Body

**Start Date:** 10/10/12

Required Date: 10/31/12

**Start Qty: 56.00** 

Required Qty: 56.00

12.04 on Listilis

Comments:

IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

MAT

123218

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B5.000X1.000	0001	Purchased	No			100	f	12.0400	0.62	36.547368	1		
7075-T6 BAR 5.000" X 1.	000			Location		Loc Qty	<u>Lo</u>	c Code					- undi. H

M123611 X 27.188

12.04

12.04

Page 1

/es	/ No				WORK ORDER NON-O		<b>NFORN</b>	<b>MANCE / UPDAT</b>	ΓE			•
			,,							QA Closed:	Date:	
er: _					DISPOSITION				AGAINST DE	PARTMENT		
No					Rework Scrap Use-as-is Work Order Update		Therm	Machining S noforming	Small Fab Finishing		d. Eng. Coor.	Engineering Quality Other
	Date	Sten	Otv		•	1		Action	on	Sign &	Verification	QC Inspector
	Date	Зіер	Qty						OII	·	·	QC IIISPECTOI
					<del></del>	AUL	LICATE	<u>JORY                                    </u>		*****		
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in ı Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instruct Mainte Mislabe Misread Offset	on Incomplete ioris Incomplete/Uncle enance eled	ear	Part Incorred Part Lost/Mi Part Moved Positioned V	ct sssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	er: _	ng Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Date Step  Date Step	Date Step Qty  Date Step Qty  Date Step Cty  Bending Centre Not Concentric to Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Description Strip in Tube	Pr:	Part   Disposition	Paris   Disposition   Rework   Scrap   Use-as-is   Work Order Update   Initial Chief Eng   Date   Step   Qty   Or Non-conformance   Chief Eng   Date   Date	Primary Content of the Content of th	DISPOSITION  Rework   Scrap   Wachining   Small Fab   Large Fab   Composite    Date   Step   Qty   Description of work order update   Initial   Action   Description    Date   Step   Qty   Order   Description   Step   Composite    Date   Step   Qty   Description   Step   Composite    Date   Step   Qty   Description   Description    FAULT CATEGORY  Rework   Skid-tube   Crosstube   Machining   Small Fab   Composite    Large Fab   Composite    Date   Step   Qty   Description   Description    FAULT CATEGORY  Rework   Skid-tube   Composite   Composite    Rework   Machining   Small Fab   Composite    Initial   Action   Description    Description   Description    FAULT CATEGORY  Rework   Skid-tube   Composite   Composite    Repair   Composite   Description    Rework   Skid-tube   Composite   Composite    Repair   Composite   Description    Rework   Machining   Small Fab   Composite    Repair   Composite   Description    Repair   C	AGAINST DEPARTMENT,  Rework Scrap Use-as-is Work Order Update Or Non-conformance    Date   Step   Qty   Description of work order update or Non-conformance   Chief Eng   Description   Date   Date   Description   Date   Description   Date   Description   Date   Date   Description   Date   Date   Description   Date   Date   Description   Date   Date	DISPOSITION  Rework   Skid-tube   Crosstube   Prod. Eng. Coor.   Rework   Scrap   Use-as-is   Work Order Update   Large Fab   Composite   Stign & Verification   Date   Step   Qty   Or Non-conformance   Chief Eng   Description   Date   Verification    Date   Step   Action   Date   Description   Date   Description    FAULT CATEGORY  Recy Store/Packaging   Large Fab   Composite   Sign & Verification   Date   Step   Qty   Or Non-conformance   Chief Eng   Description   Date   Verification    FAULT CATEGORY  Recy Store/Packaging   Large Fab   Description   Date   Verification    FAULT CATEGORY  Recy Store/Packaging   Large Fab   Description   Date   Verification    FAULT CATEGORY  Recy Store/Packaging   Large Fab   Description   Date   Verification    FAULT CATEGORY  Recy Store/Packaging   Large Fab   Description   Date   Verification    FAULT CATEGORY  Recy Store/Packaging   Large Fab   Description   Date   Verification    General   Bending   Bend   Grain   Ovalized   Over/Under tolerance   Part Norrect   Part Lost/Missing   Description   Date   Description   Descripti

Out of Secuence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 9/	1439
Description: BOD Y	Part Number: 64	4. 9710
Inspection Dwg: 646,9700 Rev: N/C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.467	± 005	1.467			#-6-	31006
R.250	±.005	R.250			R-G	
4.245	±-005	4.242			#-6	3/006
7.026	±.005	7.028			1	
10X45.0°	±.010/=1/2°	./00X45°			Vern ML-D	6
. 875	I. 005	. 8785			Mier ML	1
.352	+.005	.353			Vern ML-0	6
.13 X 45.6°	生.040/土/2	.120X450			11	
,660	± 005	· blel			H-6	31006
. 660	±.005	.660			11	
,700	±. 005	.702			Vern MC	b4 ·
,278	±. 662	277			H-G-	31006
.339	± 602	339			' ,1	,,
.352	÷ 662	.352			11	(1
.372	±.002	.372			/-	1.
1.067	±.002	1.067			11	1.
2.608	±. 002	2.608			11	ζ τ
2.750	± 002	2.750			ř •	
2.892	±.002	2.892			/-	14
3.348	± 002	3.348			~	1.
3.597	± 062	3,597			, ,	· ·
3.847	±-002	3.847			/1	1.
8.177	±.005	Ø.178	(DAC		Vern MI	06

Measured by: 14

Date: 12/10/19

Audited by: 25 / Preliminary Approval:

Date: Date: Date:

Rev	Date	Change Revised by	Approved
	10.04.14	Added preliminary approval KJ	

DART AEROSPACE LTD	Work Order:	91439
Description: BODY	Part Number:	646.9710
Inspection Dwg: 446, 9700 Rev: N/C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.201	= 005 = 001	8.202	-		Vern 71	-66
. 357	±,002	352			H-6	3/066
.544	± 6D2	.544			11	
2.195	± 002	2.195			11	
2.304	±-002	2.364			1,	
2.451	±-082	2.452			٠,	
2.639	±,002	2.639			11	
3.395	=-002	3.395			11	
3,495	±,002	3.495			11	
4.551	±.002	4.551			11	
4,595	±-002	4.595			1(	
4.687	±-002	4.687			((	
4.734	±.002	4.734			(1	
6.657	±.002	6.650			11	
			(2)			

	DAO	,	- LOAQ		
Measured by:	14	Audited by:	<b>25</b>	Preliminary Approval:	
Date:	12/10/19	Date:	12-11-15	Date:	

Rev	Date	Change	Revised by	Approved
F		Added preliminary approval	KJ	

	ENGINEERING CHANGE NOTICE NO. 0274	
APICAL	DWG NO. 646.9700 REV:N/C BY S.HUFF	DATE: 01/07/10 EFFECT ON DWG
INDUSTRIES, INC	DWG TITLE: CUTTER SUB ASSY	
INDOSTRIES, INC	APPROVED BY: ENGR 3.000 Agains & Joseph GC	MAILA TORDER PEFFI NEXT ORDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH, CHANNEL WIDTHS & D	<u> </u>
SHEET 2, ZONE C	C6, IS: SHEET 5, ZONE C2, IS:	7-(IS)
352 <sup>+,005</sup>	37.2°  (1.500)  1200  1200  (4.500)  (4.500)	-691 .750 .985 (600°)  -600 R.750  -8.750  -985  -600 R.750
	V V	0 0000
	13 X 45.0 · TYP:————————————————————————————————————	
3 R 601.3157	12 SCREW	MS27039-0818
	.9701	
F/N TC PART NUMBER	R QTY DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED	CHANGE OF MDL INSTALL INSTRUC MICA FMS MIBOM MAJOR	CATEGORY DER REVIEW REQUIRED  MINOR O YES NO

. . . . .

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
											QA Closed:	Da	ite:	
Work Orde	r.					DISPOSITION			AGAINST	DE	PARTMENT,	PROCESS		
Part No						Rework Scrap Use-as-is Work Order Update  Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite					Pro Rec/Sto	Engineering Quality Other		
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								LT CATE	CODY					
Landir	ne G	ear				General	AUI	LICAIL	<u>GC/N f</u>					
	Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
i		rorque W	raves in E	xtrusio	n [	Drawing	1	Jour of C	Lalibration					

Out of Sequence

Outside Dimensions

DQA:

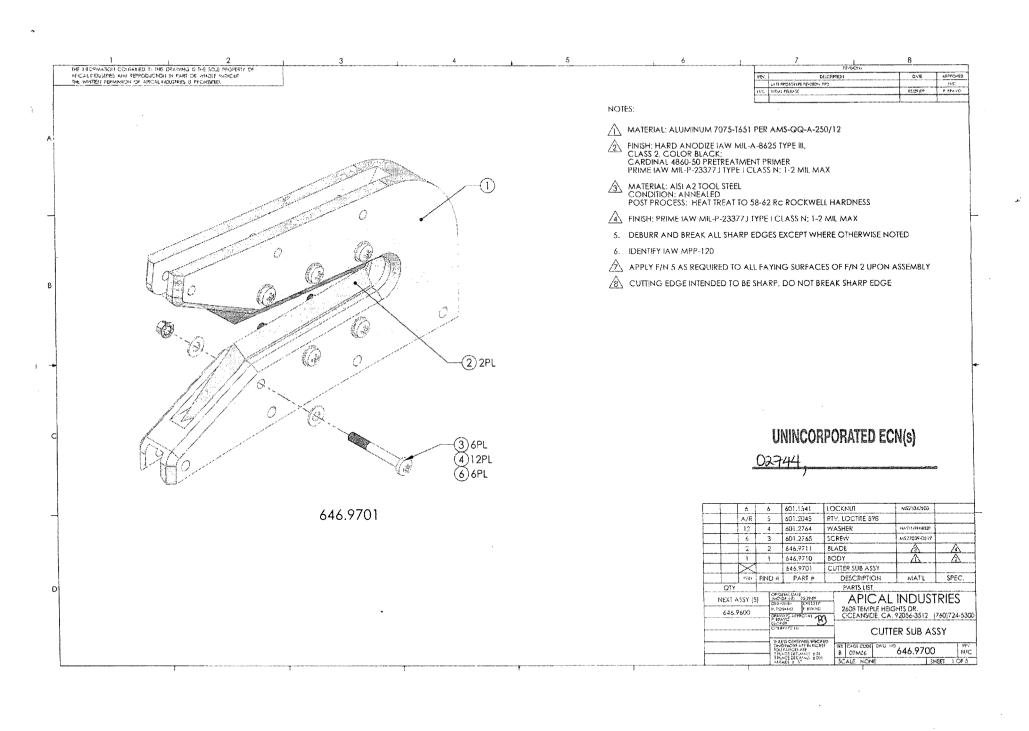
Date:

Turning Sequence

Wave/Twist in Tube

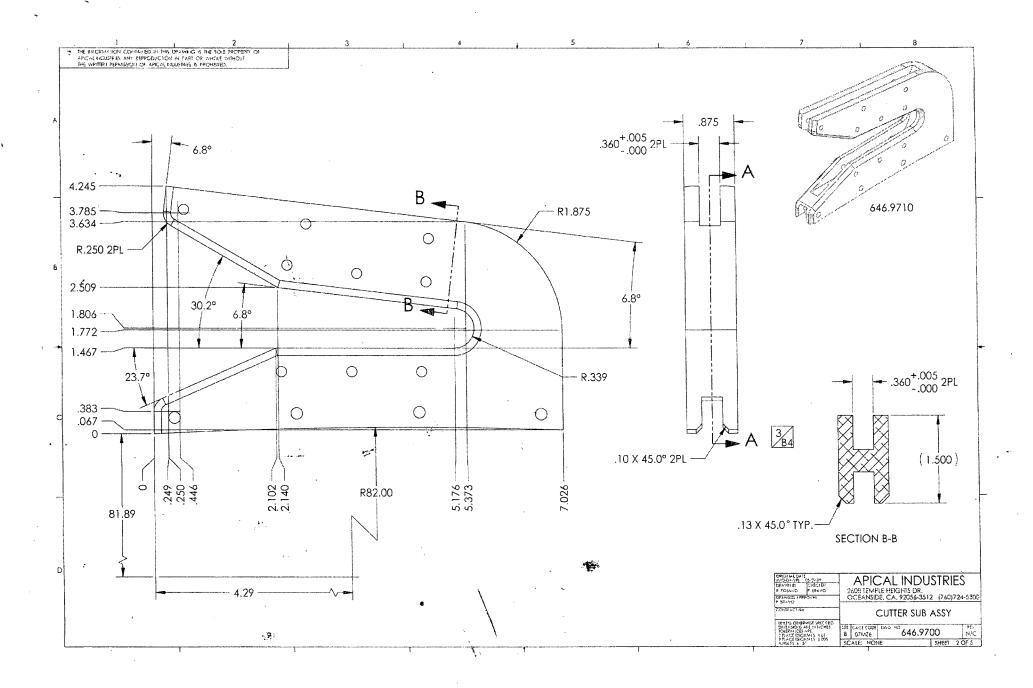
Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



									DQA:	Date:	a
NCR: Yes	/ No				WORK ORDER NON-O	Date:					
Work Order:					DISPOSITION		,	AGAINST DE	PARTMENT,	/PROCESS	
Part No.  NCR No.  Root Des					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descrip	tion of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	0	r Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data		1									
quip/Tooling											
Operator		}									
Material											
Setup											,
Other				•							·
Process						1					
Supplier											
Training									- 1		
Jnapproved					•						
	<u> </u>	•			F	AULT CATE	GC/RY				

Landing	Gear	General		_	 _		
	Bending	Bend		Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	r	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect		Weld
	Crushed/Crimped_	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved		
	Heat Treat	Countersink		Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge		Other
	Ripples in Bend	Drill Holes		Offset	¥* 		
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio	Г	Outside Dimensions			



NCR: Y	'es / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE			• •
							·		QA Closed:	Date	•
Work Orde	er:				DISPOSITION		-	AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update						Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief En	Chief Eng Description			Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		1									
Material	_										
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	Bending				Bend	Grain			Ovalized	<u> </u>	Pressure/Forced
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	Crushed/	Crimped.		_	Burrs	$\vdash$	ctions Incomplete/	'Unclear	Part Lost/M	_	Wrong Stock Pulled
	Cuffs				Contamination	$\vdash$	tenance		Part Moved		
	Heat Treat				Countersink	Mislak			Positioned \		_
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1	Ripples in				Drill Holes	Offset					
	Torque W	aves in E	xtrusion	י 📙	Drawing	Out of	Calibration				
1	Turning S	equence		- 1	Finish	Out of	Sequence				

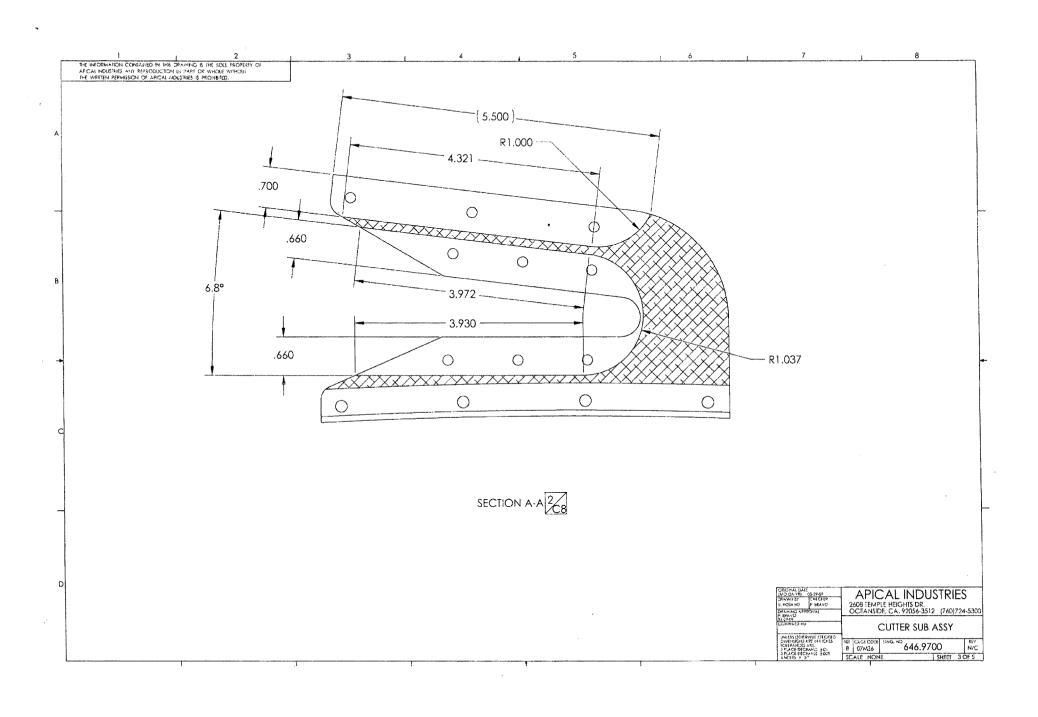
Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

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		•									DQA:	Date:		
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10161	•0.					Use-as-is	Thermoforming			Finishing	4	re/Packaging	Other	
NCR I	No.					Work Order Update		1110111	Large Fab	Composite	1,00,00	Supplier	1	
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		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld	

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

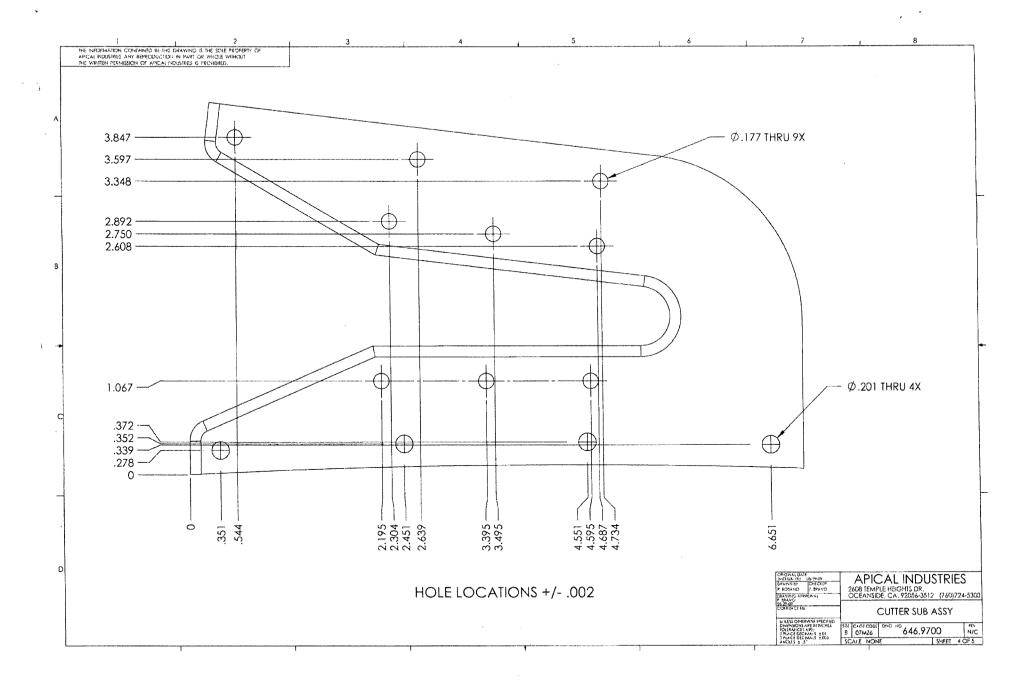
Cut Too Short

Drill Holes

Drawing

Finish

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Cracks						Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
Crushed/Crimped						Burrs		Instruct	ions Incomplete,	/Unclear		Part Lost/M	issing		Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved				
		Heat Trea	at			Countersink		Mislabe	led			Positioned \	Vrong		_
		Inspection	n Strin in	Tuhe		Cut Too Short		Misreac	1	[		Power Loss	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

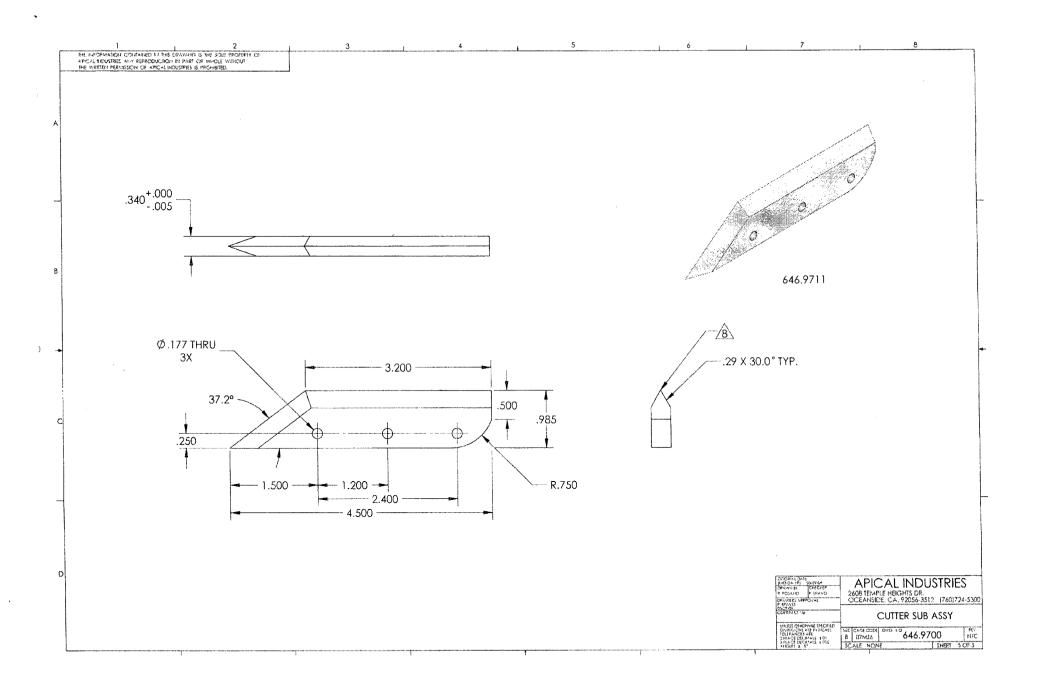
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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										DQA:	Date:	-
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Work Orde	vr:				DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
WOIR Olde	.1.				Rework	1		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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	Cracks				Broken/Damaged		Inspecti	or Incomplete	·	Part Incorre	ct	Weld
	Crushed/	'Crimped	-		Burrs		i	ions Incomplete/	'Unclear	Part Lost/M		Wrong Stock Pulled
Cuffs					Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned \		7
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	ł	٦_	Power Loss,	/Surge	Other
ſ	Rinnles in	Rend		[	Drill Holes	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62107

Date: 12-Dec-12

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Canada

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		Silip Via		
Quantity	Description			
1	Part: ASST		Rev:	
lot				
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	5 PCS 647.1612			
•	2 PCS 647.1713			
	6 PCS 647.1811			
	PC 647.1816 PC 647.1817			
	8 PCS 647.1818			
	11 PCS 646.3210			
	20 PCS 646.3313			
	10 PCS 646.3717	•		
	20 PCS 646.3717			
	16 PCS 647.4610			
	10 PCS 649.4811			
	10 PCS 649.4812			
	24 PCS 649.4814			
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	3 PCS 647.7919			
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	MIL-A-8625 TYPE III CLASS 2 Job: 20120768	DO: DO40506	l !	
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	Certificate of Co	·		
	A.T.G. Industries certifies that all items with all requirements, specifications ar	s in this shipment are in one of the shipment are in one of the shipment are in the shipment are s	conformance n the purchase order.	
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	DATE: 12/12/12		• //	



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Number: 62107

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Canada

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Ph: 613-632-5200

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